

Date: Wednesday, 2/6/2008 11:12:15 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR PROTECTOR FWD LH
 Job Number : 37251
 Estimate Number : 11227
 P.O. Number :
 This Issue : 2/6/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : THERMOFORMING
 Previous Run : 37108
 Written By :
 Checked & Approved By :
 Comment : Est Rev.A 04.07.01 New issue KJ/JLM
 Est. Rev B. 07.16.2007 Thermoform in house DL

Part Number : D32811
 Drawing Number : D3281 REV B C
 Project Number : N/A
 Drawing Revision : B C
 Material :
 Due Date : 2/18/2008 Qty: 7/10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 F6006 701 lexan black



Comment: Qty.: 4.0000 sf(s)/Unit Total: 40.0000 sf(s)
 lexan black

M106995

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/02/06.

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

X 2 SCRAP PTO

Dwg. Rev. S

Folio Rev. B

08/02/06

X 7 BB

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/02/26 BB

5.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08/02/26
 08/02/27

X 1 BB
 X 6 BB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3281-1 PAR #: N/A Fault Category: Prod/Thermoforming NCR: (Yes) No DQA: D Date: 08/03/04
 QA: N/C Closed: 10 Date: 08/03/06

NCR: <u>37251</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>04/03/03</u> <u>3.</u>	<u>3.0</u>	<u>Did not Form correctly</u> <u>R.L. Human error</u>	<u>[Signature]</u> <u>aspm</u>	<u>Scrap and destroy</u> <u>no replace no mat.</u> <u>Qty (12)</u>	<u>BB</u> <u>04/03/27</u>	<u>[Signature]</u> <u>08/03/03</u>	<u>[Signature]</u> <u>08/03/03</u>	<u>[Signature]</u> <u>08/03/03</u>

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 11:12:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD LH

Job Number: 37251

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/02/26 (x7)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/03 (x7)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 2006 08/03/04 (x7)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/04 (7)

Job Completion



U 08-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37251
Description:		Part Number: D3281-1
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: RB Date: 08/02/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.95	.030	.954	✓			
0.25	.030	.251	✓			
18.6	.100	18.62	18.62 ✓			
17.1	.100	17.15	17.15 ✓			
11.7	.100	11.675	11.675 ✓			

Measured by: RB Date: 08/02/26
Audited by: [Signature] Date: 080227
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

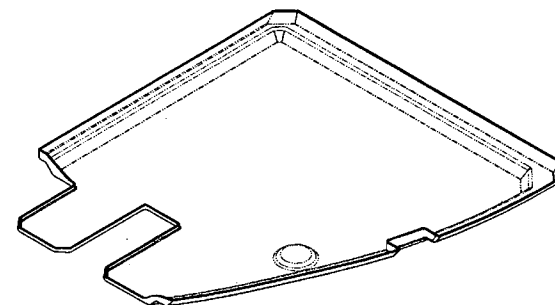
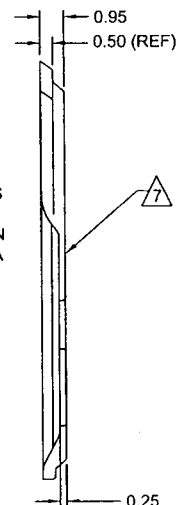
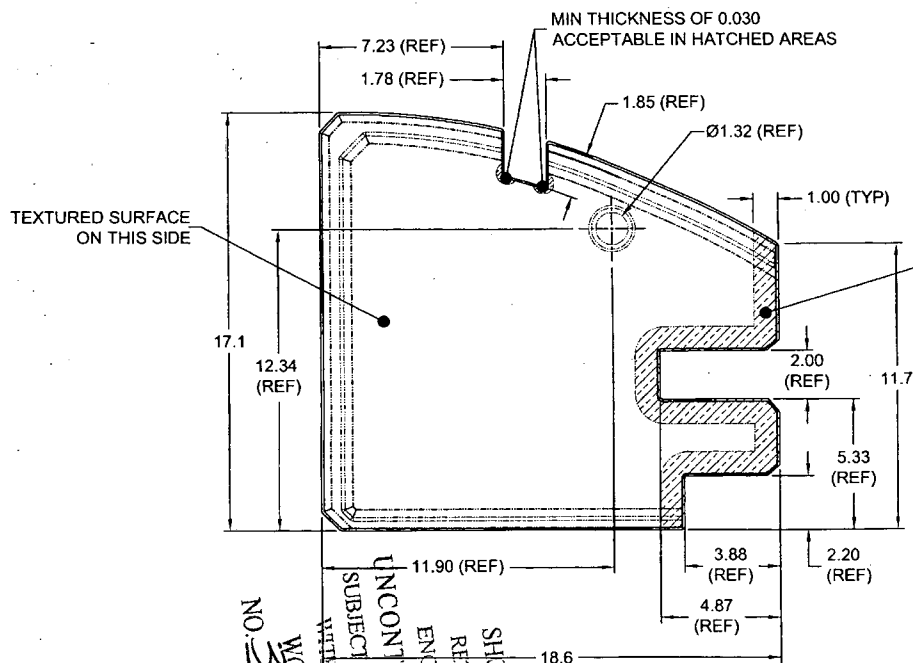
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07-11-06

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D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" THICK WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

D3281-1 FLOOR PROTECTOR



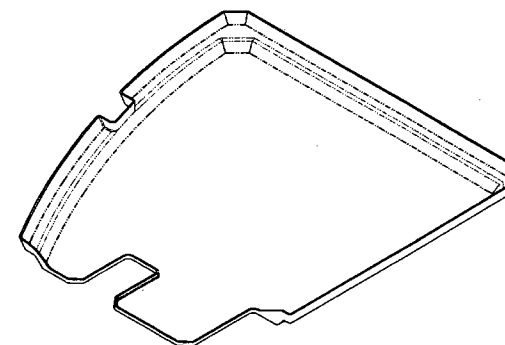
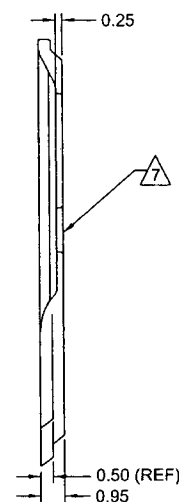
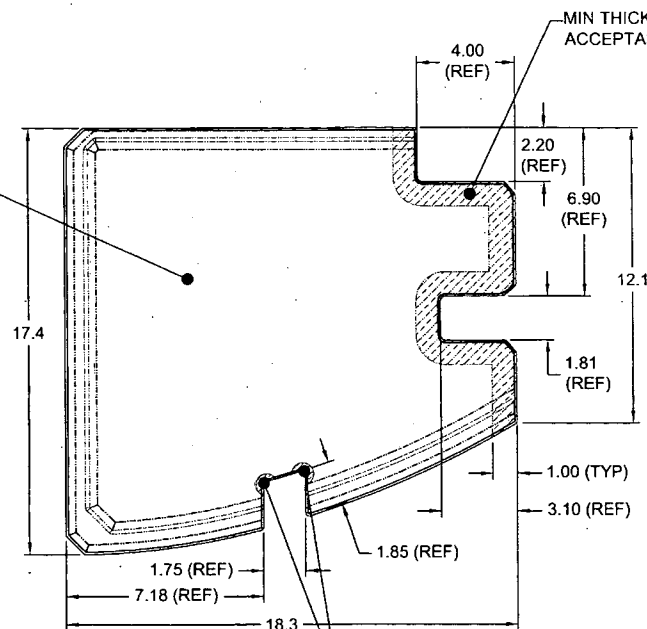
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	LE		
CHECKED	PA		
MFG. APPR.	WJP		
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3281
TITLE FLOOR PROTECTOR
REV. C
SHEET 1 OF 3
SCALE NTS

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TEXTURED SURFACE
ON THIS SIDE



MIN THICKNESS OF 0.030
ACCEPTABLE IN HATCHED AREAS

D3281-2 FLOOR PROTECTOR

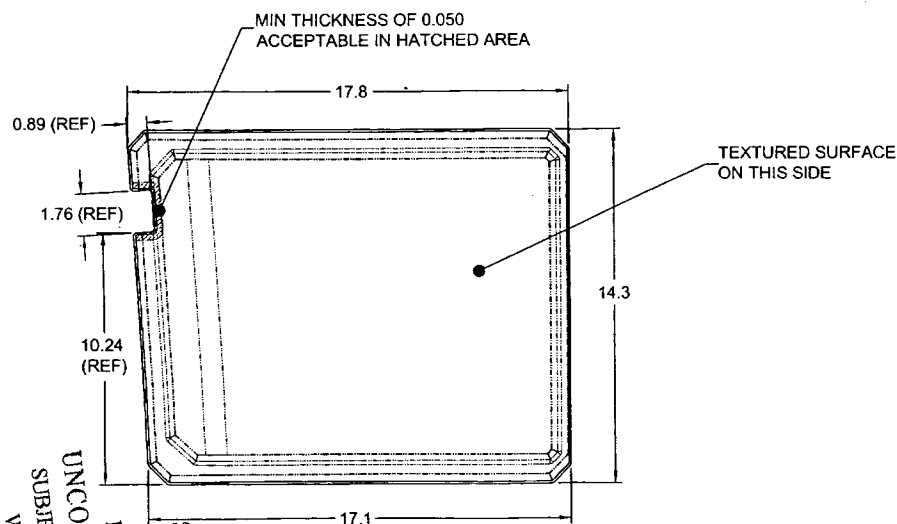
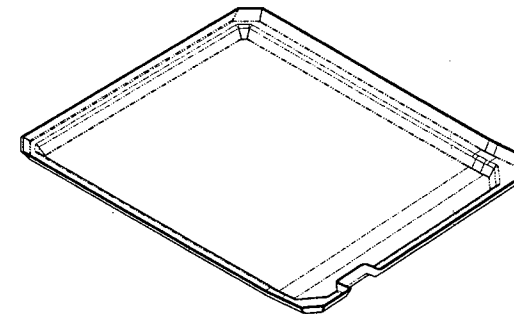
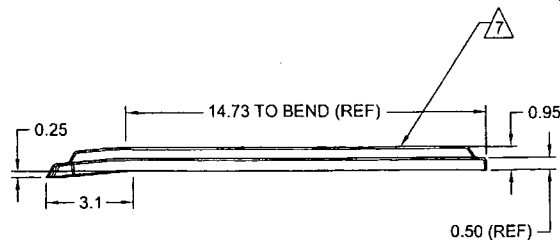
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D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022 TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	DART AEROSPACE LTD	
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MFG. APPR.	BL	D3281	SHEET 2 OF 3
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DE APPR.		FLOOR PROTECTOR	NTS
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D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

D3281-3/-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	92	DART AEROSPACE LTD	
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CHECKED	PM	DRAWING NO.	REV. C
MFG. APPR.	WJP	D3281	SHEET 3 OF 3
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	FLOOR PROTECTOR	NTS
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